



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D135-1027-143
Job Sheet 170186

Accounting Job RD17-1027-01



Part No: D135-1027-143

Job Qty: 1 ea

Part Name: MID HEIGHT FWD Crosstube Assembly



Part Weight: 0 lbs

Status: Scheduled

Priority: High

Job Created: 1/11/18

Job Tracking No:

Due Date: 1/19/18

Created By: Mario Poulin

Type: R+D

Description:

Note: D135-1027-143 REV.A IPP REV:A 17.09.08 NEW ISSUE DD VERF:DP

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea	1/18/18	1/18/18	0.00	0.00	Start Up Container		
100	HandFinish	1 pcs	1/18/18	1/18/18	0.00	0.25	HandFinish1		
110	QC	1 pcs	1/18/18	1/18/18	0.00	0.00	QC7-1		APR 26 2018
120	HandFinish	1 pcs	1/18/18	1/18/18	0.00	0.25	HandFinish4		APR 26 2018
130	QC	1 pcs	1/18/18	1/18/18	0.00	0.00	QC5		APR 26 2018
140	SprayPaint	1 pcs	1/19/18	1/19/18	0.00	1.00	Spray Paint		APR 27 2018
150	QC	1 pcs	1/19/18	1/19/18	0.00	0.00	QC14		APR 27 2018
170	Packaging	1 pcs	1/19/18	1/19/18	0.00	0.00	Packaging3-1	L6050	MAY 02 2018
180	QC21-SA	1 Ea	1/19/18	1/19/18	0.00	0.00	QC21		MAY 07 2018

Part Op 100 - ***PRIOR TO CHEMICAL CONVERSION*** SCRIBE DART P/N AND B/N ON INSIDE OF CUFF PER QSI 044 6.4

Descriptions: 120 - INSTALL THREADED ROD AS PER DWG AND APPLY LOCKTITE 263 (NOTE 9) AND SEAL BETWEEN THE NUT AND CROSSTUBE USING SEALANT(NOTE10) 138857 Proseal 138884 exp 9/18

140 - ***MASK PRIOR TO PRIME AND PAINT AS PER NOTE11, BOTH ENDS*** 1- PRIME INSIDE AND OUTSIDE PER QSI005 4.2.1.3.3 (FLOAT SKIDTUBE PRIMER) BATCH: 138408 2- PAINT OUTSIDE SURFACE AS

PER QSI005 4.2.2.4 (FLOAT SKIDTUBE PAINT) BATCH: 138819 3- COAT INSIDE SURFACE WITH LPS

PROCYON AS PER DWG, QSI005 4.8 4- AFTER FINISH APPLY A 1 INCH CENTER LINE ON TOP OF CROSSTUBE WITHIN 0.1" OF CENTERLINE QSI 044 6.1(SEE NOTE 12 AND 13)

N/A 1/18/18

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	D135-1027-153 169678	①	0	0	0
	D5511-1 166507	②	7	0	0
	MS35650-304 137878	④	60	0	0
	NAS1149D0363J 5015269	④	4,315	0	0

Part Specifications



1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S066235



Part: D135-1027-143

Job No: 170186

Serial No/Batch: S066235

Revision: A

Inspector:

Plex 1/11/18 10:23 AM dart.poulin.mario

P.T.O.

mid 19 June 2019



WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____
QA Closed: [Signature] JUN 19 2019
Date: _____

Work Order update only ☐

Work Order: <u>170186</u>		DISPOSITION		AGAINST DEPARTMENT/PROCESS															
Part No. <u>DJS-627-143</u>		Rework ☒ Scrap ☐ Use-as-is ☐		Skid-tube Machining ☐ Thermoforming ☐ Large Fab ☐		Cross tube Small Fab ☐ Finishing ☐ Composite ☐		Water Jet Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐		Engineering ☒ Quality ☐ Other ☐									
NCR No. <u>19-7180</u>		Suspected Unapproved		QTY Effective: <u>140</u>															
Date: <u>16/5/2</u>		Step #: <u>140</u>		Disposition															
Description Work Order Deviation				Completed By															
Dwg cells for Pacyon on inside surface of crashtube. Not required. Difficult to apply and process not done on other crashtubes. Dwg will be revised to remove Pacyon before STC approval <u>AB</u> MAY 02 2019				MRB (QSI042) Approval															
				12 14/5/2															
				9-89 14/5/2															
				Lead hand / Supervisor Approval Verification															
				DAS 9															
				13-05-17															
				QC / QA Coordinator Approval															
				DAS 9															
				13-05-17															
FAULT CATEGORY																			
Root Cause				Pressure/Forced				Temperature/Cure				Power Loss/Surge				Positioned Wrong			
Environment				Bending				Set-up				Folio/Program				Outside Dimensions			
Design				Centre Not Concentric				BOM/Route				Grain				Over/Under tolerance			
Doc/Data				Cracks				Broken/Damage/Defect				Weld				Part Incorrect			
Equip/Tooling				Crimp/Kink/Ripple/Wave				Inspection Incomplete/Unqualified				Wrong Stock Pulled				Part Lost/Missing			
Handling/Pre				Cuffs				Contamination				Out of Sequence				Part Moved			
Material				Crushing				Countersink				Off-set				Drawing			
Internal Transport				Heat Treat				Cut Too Short				Mislabeled				Finish			
Tribal Knowledge				Wave/Twist in Tube				Instructions Incomplete/Unclear				Fit/Function				Misread			
LOA				Marks/Chatter				Drill Holes				Misaligned/off center				Turning Sequence			
Substation																			
Past Expiry Date																			
Misidentified																			
				OTHER :															